



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-3
Job Sheet 186625



Part No: D3278-3

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP . A 04.04.19 New issue KJ/JLM IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	60 pcs		11/30/18	0.01	1.17	Waterjet - Flow		SL 18/11/20
120	QC	60 pcs		11/30/18	0.00	0.00	QC8		38
130	Small Fab	60 pcs		11/30/18	0.00	1.06	Small Fab-3		38
140	QC	60 pcs		11/30/18	0.00	0.00	QC5		38
150	Packaging	60 pcs		11/30/18	0.00	0.00	Packaging3	57.029	DEC 03 2018
160	QC21-SA	60 Ea		11/30/18	0.00	0.00	QC21		DEC 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINS0.125	Black Delrin Sheet .125	2.0640 sf (.0344 ea)	100-Waterjet - Flow - 1	M138095

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	MDELINS0.125	2	10	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	1.980inches $\pm$ 0.030	2.010 1.950	1.981	
2	Spacer	1.980inches $\pm$ 0.030	2.010 1.950	1.985	
3	Spacer	1.480inches $\pm$ 0.005	1.485 1.475	1.481	
4	Spacer	0.250inches $\pm$ 0.010	0.260 0.240	0.252	
5	Spacer	1.480inches $\pm$ 0.005	1.485 1.475	1.480	
6	Spacer	0.250inches $\pm$ 0.010	0.260 0.240	0.251	
7	Spacer	0.098inches $\pm$ 0.005 - 0.000	0.103 0.098	0.099	
8	Spacer	0.130inches $\pm$ 0.030	0.160	0.127	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

Completed By _____
 d / Supervisor _____
 al Verification _____
 Coordinator _____
 approval _____



Container No: S129522
 Part: D3278-3
 Job No: 186625
 Serial No/Batch: S129522
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's
 Date: 11/20/18



Root Cause

Environment ☐	No Re-verification ☐	Pressure/For ☐	ed Wrong ☐
Design ☐	Operator ☐	Bending ☐	Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not C ☐	ider tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	orrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/R ☐	t/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

9	Spacer	0.125inches ± 0.010	0.100	0,125
			0.135	
			0.115	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
				Completed By																					
				Lead hand / Supervisor Approval Verification																					
				QC / QA Coordinator Approval																					
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER :																									